User

Monday, 26/05/2008 12:57:45 PM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number **Estimate Number**

: 39490

: 13264

P.O. Number

: 26/05/2008 This Issue

: NC Prsht Rev. : //

First Issue : 38602

Previous Run

Written By

Checked & Approved By

Comment

Type

new issue 08-05-26 DD verified by:EC

: R & D SM/MED FAB

Part Number

Drawing Name

: D3777041

: PROTO

: CLAMP

Drawing Number

: D3777 PROTO 08.05.26 Project Number : N/A

Drawing Revision

Material **Due Date**

: 28/05/2008

Qty:

2 Um:

FOR ENGINEERING USE ONLY

Each

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description:

304/316 .032 Sheet

1.0

M304S22GA

Comment: Qty.:

0.0210 sf(s)/Unit Total:

0.0420 sf(s)

304/316 .032 Sheet

Batch: 63 (S9

2.0



Comment: FLOW WATER JET 1-Cut as per Dwg D3777

Dwg Rev: PREL

Prog Rev: DEEL

1B8-5-26



2-Deburr if necessary

3.0

QC2



B8-5-2C



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



NGINEERING



u8. US. U

Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



08/05/26

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr any rough edges

2- Form as per Dwg D3777

Monday, 26/05/2008 12:57:45 PM Date: User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: CLAMP** Job Number: 39490 Part Number: D3777041 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Pick Packing Kit 8.0 D2182B013 Rubber cushion Comment: Qty.: 1.0000 Each(s)/Unit Total: .2.0000 Each(s) 4.000 **Rubber Cushion** A FF 08-06-05 batch: SMALL & MEDIUM FAB RESOURCE 1 Comment: Assemble rubber cushion as per dwg D3777 QC5 INSPECT WORK TO CURRENT STEP 10.0 **NGINEERING** APPROVAL 62.66 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 11.0 **PACKAGING** Comment: PACKAGING RESOURCE #1 Identify and Stock W 08,06,05 Location: 12.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Receiving Report

	ate: <u>· () /9/2.0</u> upplier: <u>C) /P//2.0</u> Yes <u>V</u> No Ves No Cash Cr L	R W S Q	Batc Dart elease Note / /aybill Attache hipment Com IC6 Inspection /ork Order	P/O:	200/ es Nees Ne	
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
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		Initials	of receiver (if shipment	OK) Level	12
Production/Ad Date Received/Cos Initial	國 GC/09/2	2			Location	on

DART AEROSPACE LTD	Work Order:	⁷⁹⁴⁹⁰
Description: CLAWO	Part Number:	D3777 -041
Inspection Dwgn 377)-CHI Rev: DREL.		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by:	R	Audited by:	Q	Prototype Approval:	q
Date:	8-5-26	Date:	08.06.05	Date:	08.06.05

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #:	D412-778	Job # : 00079	Date: 08.05.26

Product Name: Comfort Seat

Requested By: CP

Design Manager Approval:

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3758-041	SM	CLAMP	08.05.26	Υ	08.05.28		
2	D3777-041	SM	CLAMP	08.05.26	Υ	08.05.28		

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KEC	XXXX			<u> </u>	<u> </u>	222		L1		問題問				

TEST RESULTS ----

CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds or call 248-233-5682. We hereby certify that the material above complies with the following specifications:

ASTM-A240

ASME-SA240

ROHS COMPLIANT

TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT PCS ! TAG NO

72.00 LB -GULF 0CK6545 354877

PCS ! TAG NO

QUANTITY UOM VENDOR VEND PO HEAT/LOT

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GULF NORTHERN

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INSPECTION CERTIFICATE 3.1	To: EN 10204 To: EN 10204 GULF & NORTHERN TEADDOG CORP. ZOOI MT. EFFRAM AVE. HARRES T CAMDER, N7 08104 U.S.A.	moover No. 28 Finish	METERITOR (MM.) ASTIN A240 / A240M - 06 ASTEL A666 50 ASSES SECTLIN, ED. 04 ADD. 0558A240M QQ-5 764D 02.18 MEL-5 5057 202 (44.50) AMS 5313-Q: 01/99	Tolinamia ASTM A480 / A480M-05	Parameter (0.032 in x 48.00 in x COIL	SECTION POSICIONES	States and state %	C 0.090 0.046 8 0.030 0.093 P 0.046 0.093 NA 2.000 1.4	8,000 10,500 18,000 20,000	0.1000	9 G		8 0000	The preschibilises to Harders requirement of Nace MC-017503 NO WELDING, NO CONTAMINATION WITH MERCURY	

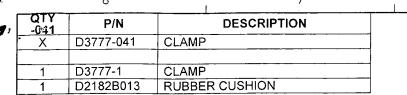
Dart Aerospace Ltd

W/O:			WORK ORDER CI	HANGES				,
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #·	Fault Category:	NCR: Yes	No DO	۸.	Date:	

Part No:	PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:
			QA: I	1/C C	losed:	Date:

NCR:			WORK ORI	DER NON-CONFORMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	Approval	Annroval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
૮ ૪.૯૯૫	l	MATIL LERT CALLS UP ASTM A240	9 08.06.09 per OSI 042	ASTM IS AN ACCENTRIBLE SPEC FOR M3045	-		08.06.09 per QS1042	

NOTE: Date & initial all entries



-D2182B013 RUBBER CUSHION -D3777-1 CLAMP

D3777-041 CLAMP

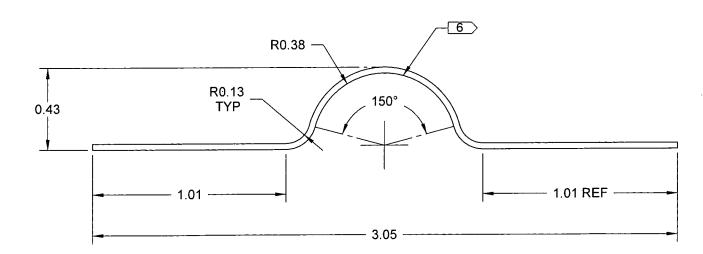
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

8

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING 08.0526

					1	
Α	New iss	ue		CP	08.04.25	
REV.		į l	DESCRIPTION	BY	DATE	
DESIGN			DART AEROSPACE LTD			
DRAWN			HAWKESBURY, ONTARIO, CANADA			
CHECKED			DRAWING NO.		REV. A	
MFG. APPR.			D3777	SHEET 1 OF 3		
APPROVED			TITLE		SCALE	
DE APPR.		:	CLAMP		NTS	
DATE 08.04.25			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT			

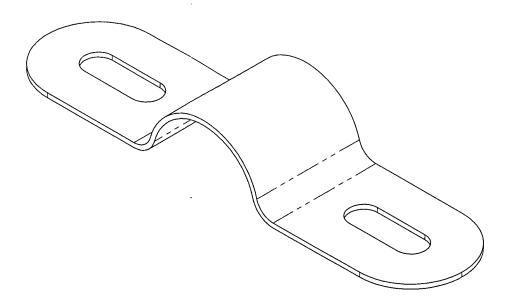
0.750 REF



D3777-1 CLAMP

8

NOTES:
1) MATERIAL: MAKE FROM D3777-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1"USING FINE POINT PERMANENT MARKER
7) WEIGHT: 0.02 lbs



D

PROTOTYPE
PLEASE RETURN ALL ISSUED
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DESIGN	DART AEROS	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONT	rario, canada		
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MFG. APPR.	D3777	SHEET 2 OF 3		
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DATE 08.04.25	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SI NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COM	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

3

0.350 REF 0.274 0.274 TYP TYP 0.750 0.553 TYP R0.375 TYP Ø0.203 TYP

D3777-1F CLAMP

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING 08.05.26

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NOTES:
1) MATERIAL: AISI 304/316 SS SHEET, 0.031 THICK (REF DART SPEC. M304S22GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
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CHECKED	DRAWING NO.	REV. A	
MFG. APPR.	D3777	SHEET 3 OF 3	
APPROVED	TITLE	SCALE	
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DATE 08.04.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		